

Work Order ID 141604

Friday, February 05, 2016 8:46:00 AM

141604

ship off march 17th Page 1

Item ID: D3295-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacment Interior Window For -111
 Start Date: 2/3/2016 Start Qty: 400 ***4*** Cust Item ID:
 Required Date: 2/3/2016 Req'd Qty: 400 ***4*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: FEB 09 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3295	E

100 FLOW WATER JET 0.00
100
 Waterjet 0.01
 FLOW CNC Waterjet
 Memo
 ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING PARTS
 1-Cut D3295-1 as per Dwg D3295
 Dwg Rev: GE
 Prog Rev: _____
 2-Remove plastic, clean and wrap in saran wrap.
 3-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC 0.00
 Quality Control
 Memo

8 16-3-4 14
 DAS
50
 9-89

8 16-3-4 14
 DAS
50
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

Work Order ID 141604

Friday, February 05, 2016 8:46:00 AM

141604

Page 3

Item ID: D3295-041 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Replacment Interior Window For -111
Start Date: 2/3/2016 **Start Qty:** 4.00 ***4*** **Cust Item ID:**
Required Date: 2/3/2016 **Req'd Qty:** 4.00 ***4*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST 436</u>	0.00							
150									
Packaging	Memo	0.00					<u>Sx</u>		<u>[Signature]</u>
Packaging								07/03/16	
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01					<u>MLJ</u>		<u>MAR 07 2016</u>
Quality Control									

[Signature]
 16-3-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, February 05, 2016 8:46:03 AM

Page 1

Work Order ID: 141604

141604

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacment Interior Window For -111

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-9034-01		Purchased				100	sf	65.8000	1.24	5.221053			
MI FXS 125-9034-01									**				
1/8" 9034 Lexan Sheet													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					MAT019	65.8							
					125052	65.8							
D2728-1		Manufactured		Yes		140	Each	0.0000	1	4			
D2728-1									**				
Dart Logo Label Small													

16-153-4 JL
13.611
DAS
36
9-89
16/03/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

DART AEROSPACE LTD		Work Order:	141604
Description: Window		Part Number:	D3295
Inspection Dwg: D3295	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	157	—		DL02	
17.13	+/-0.030	17.13	—		tape	
10.43	+/-0.030	10.43	—			
14.35	+/-0.030	14.35	—			
8.98	+/-0.030	8.98	—			
0.625	+/-0.010	0.625	—			
7.109	+/-0.010	7.109	—			
15.845	+/-0.010	15.845	—			
2.308	+/-0.010	2.308	—			
5.420	+/-0.010	5.420	—			
9.402	+/-0.010	9.402	—			
1.312	+/-0.010	1.312	—			
6.260	+/-0.010	6.260	—			
12.520	+/-0.010	12.520	—			
0.313	+/-0.010	0.313	—			
3.750	+/-0.010	3.750	—			
8.150	+/-0.010	8.150	—			
9.006	+/-0.010	9.006	—			
0.125	+/-0.010	0.125	—			
	DAS					
	50					
	9-89					

Measured by:	<i>AL</i>	Audited by:	DAS 38	Preliminary Approval:	
Date:	16-3-4	Date:	9-89 MAD 04 2016	Date:	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	<i>AA</i>

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 141604 MJS
1602-09

RELEASED
2012-11-21

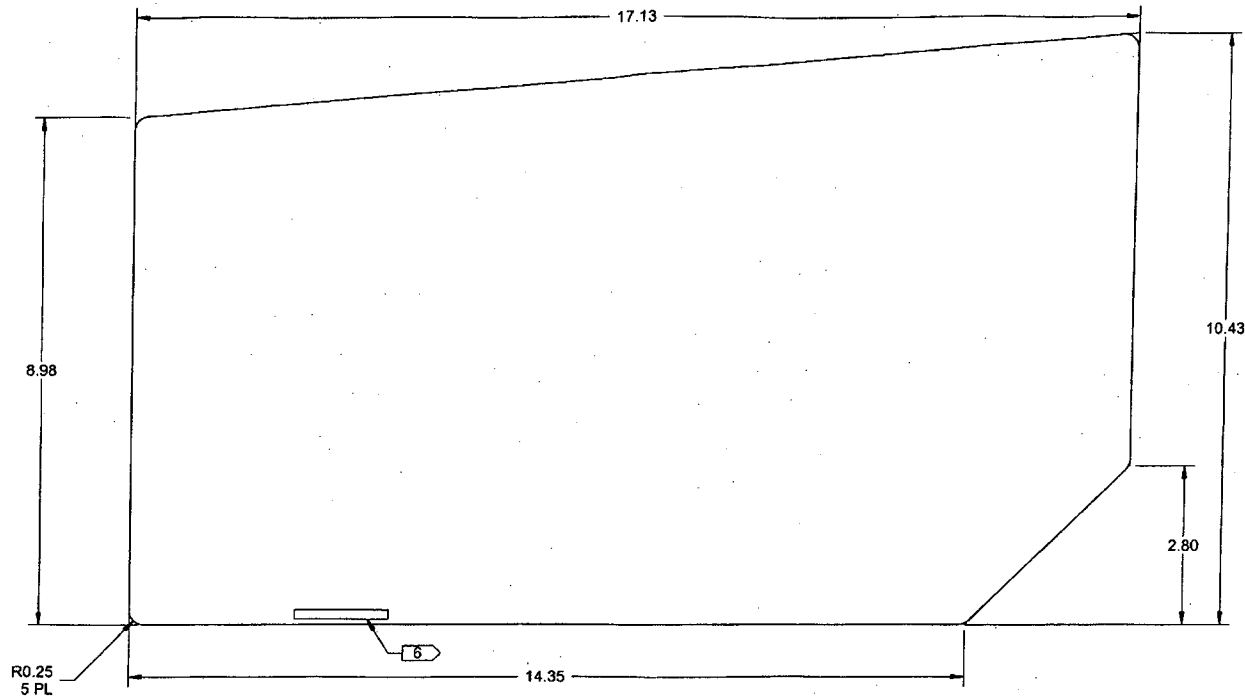
D3295-041 FLOOR WINDOW

D3295-041B FLOOR WINDOW, BLANK

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: D3295-041/-041B = 0.87 lbs

E	ADD D3295-041B/-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3295 TITLE FLOOR WINDOW REV. E SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
APPROVED	97		
DE APPR.	97		
DATE	12.11.15		



D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	gp	DRAWING NO.	REV. E
MFG. APPR.	gp	D3295	SHEET 3 OF 3
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	FLOOR WINDOW	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. UNLESS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	